

Work Order ID 74717-1

Wednesday, October 05, 2011 12:58:55 PM

Page 1

Item ID: D2010-104

Revision ID:

Accept

Item Name: Mirror Arm 369/500

Start Date: 10/5/2011 Start Qty: 10.00

Required Date: 10/14/2011 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: M.L.J.

Date: 11/10/08 Tooling:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2010

Rev D

100



Brake NC

Brake NC

NC BRAKE

0.00

Memo

0.00

Punch per Dwg. D2010-104 and Spec Control Dwg D2727  
Identify as D2010-104

SB 11/6/08

(10)

110



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

1- Bend as per Dwg D2010 using bending Jig D2010-104T2  
2- Deburr ends

SB 11/6/08

(3)

120



Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

1- flare before installing plug as per dwg D2010  
2- Install D2057 plug as per Dwg D2010

SB 11/6/08

(3)

# Work Order ID 74717

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Item ID: D2010-104

Revision ID:

Accept



Setup Start



Item Name: Mirror Arm 369/500

Stop



Start Date: 10/5/2011 Start Qty: 10.00

Required Date: 10/14/2011 Req'd Qty: 10.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 units/20

(x3)

140



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:00

320 OF

10:30

0.00

QC3- Inspect Part Finish

0.00

Memo

0.00

150



QC

Quality Control

3x of m-f 11/10/21

3 hr 11-10-21

M117338

# Work Order ID 74717

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Item ID: D2010-104

Revision ID:

Accept

Item Name: Mirror Arm 369/500

Start Date: 10/5/2011 Start Qty: 10.00

Required Date: 10/14/2011 Req'd Qty: 10.00

Reference:

Cust Item ID:

Customer:

Setup Start

Stop

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Packaging

Packaging

Identify as per dwg & Stock Location

220

0.00

Memo

0.00

11/10/21/30

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/10/24

ME

11-10-21

# Picklist Print

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Work Order ID: 74717

Parent Item: D2010-104

Parent Item Name: Mirror Arm 369/500



Start Date: 10/5/2011

Required Date: 10/14/2011

Start Qty: 10.00

Required Qty: 10.00

## Comments:

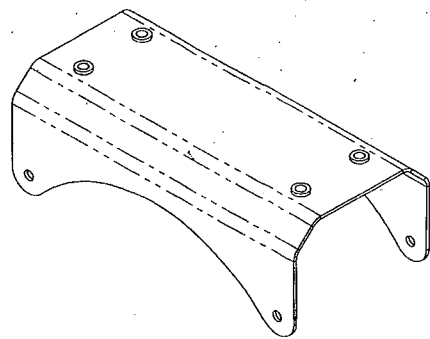
IPP AU04.02.17 New issue KJ/JLM  
 IPP Rev:B 08-05-27 as per ECN1195P DD verified by:EC  
 IPP Rev:C 08-06-20 rev.D as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049		Purchased	No			100	f	394.5211	1.5	15.78947			
304 RD Tube .500 x .049W													
<div> <div> <u>Location</u>            MAT017            111814            115010            117598            119087         </div> <div> <u>Loc Qty</u>            394.521058            2.23            145.421058            66.87            180         </div> <div> <u>Loc Code</u>          </div> </div>													
D2057		Manufactured	No			110	Each	27.0000	1	10			
Plug													
<div> <div> <u>Location</u>            GA            71888            ST006            71103         </div> <div> <u>Loc Qty</u>            20            20            7            7         </div> <div> <u>Loc Code</u>        </div> </div>													

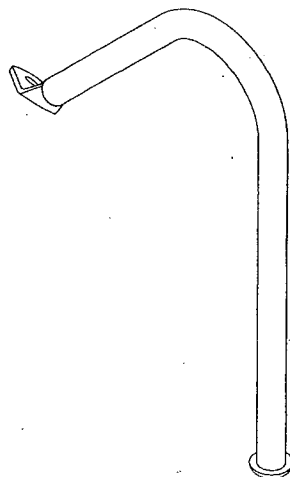
SB 11/10/20

SB 11/10/20

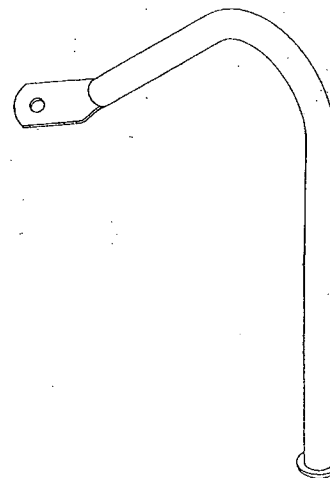
3



**D2010-101 MIRROR BRACKET**



**D2010-103 ARM**



**D2010-104 ARM**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. ~~111~~ 74717

M.L.J.

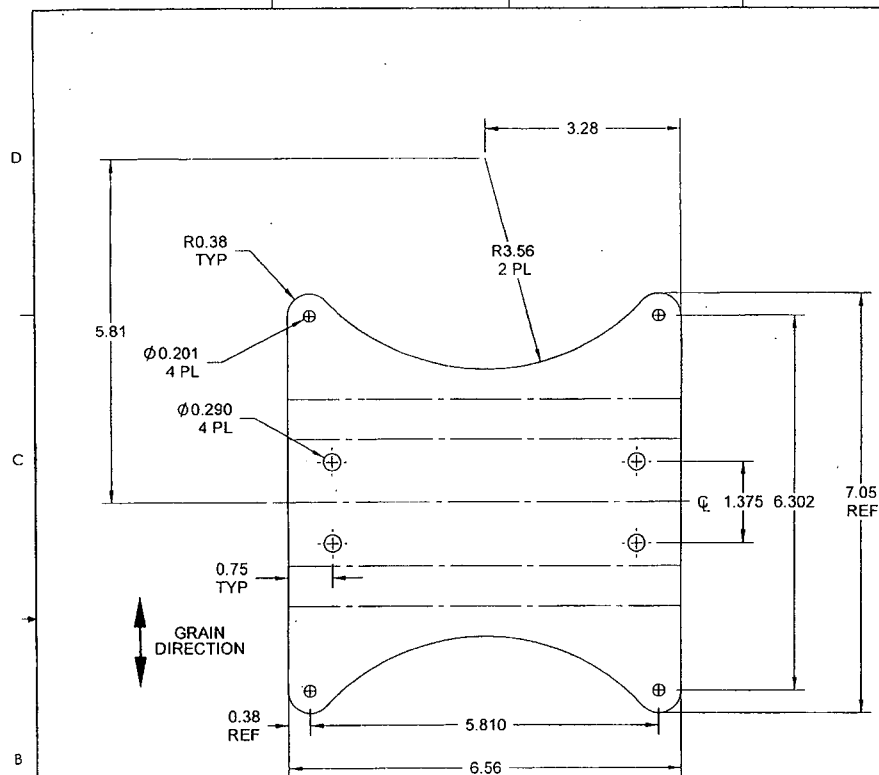
11/10/05

**RELEASED**  
08.06.10

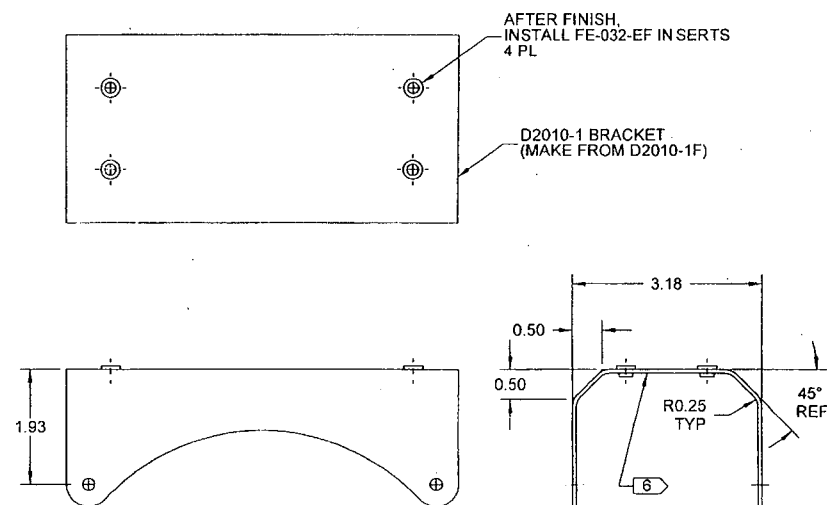
REV.	DESCRIPTION	BY	DATE
D	REDRAWN IN SOLIDWORKS; ADD D2010-1F FLAT PATTERN FOR D2010-101 (ZN B7-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN B1-3, B1-4); REASON: TUBING CRACKING DURING SERVICE	PH	08.06.10
C	1.93 WAS 2.00; 0.50 WAS 0.62	KE	97.10.31
B	7.90 WAS 10.90	JB	92.03.17
A	NEW ISSUE	JB	90.12.15
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D2010</b> REV. D SHEET 1 OF 4 TITLE <b>MIRROR BRACKET</b> SCALE <b>NTS</b>	
DRAWN	JB		
CHECKED	JB		
MFG. APPR.	JB		
APPROVED	JB		
DE APPR.	JB	DATE <b>08.06.10</b> <small>COPYRIGHT © 1990 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

74717

QTY -101	P/N	DESCRIPTION
X	D2010-101	MIRROR BRACKET
1	D2010-1	BRACKET
4	FE-032-EF	INSERT



**D2010-1F FLAT PATTERN**








**D2010-101 MIRROR BRACKET**

RELEASED  
28-06-19/11

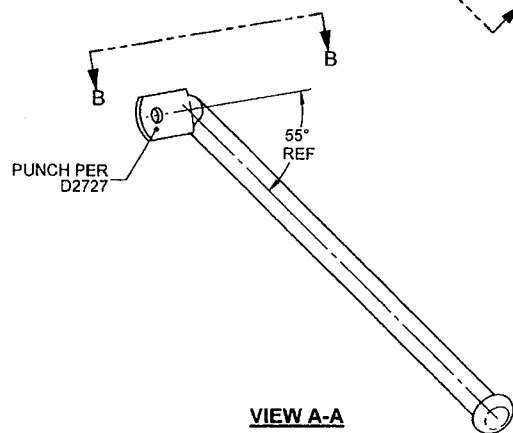
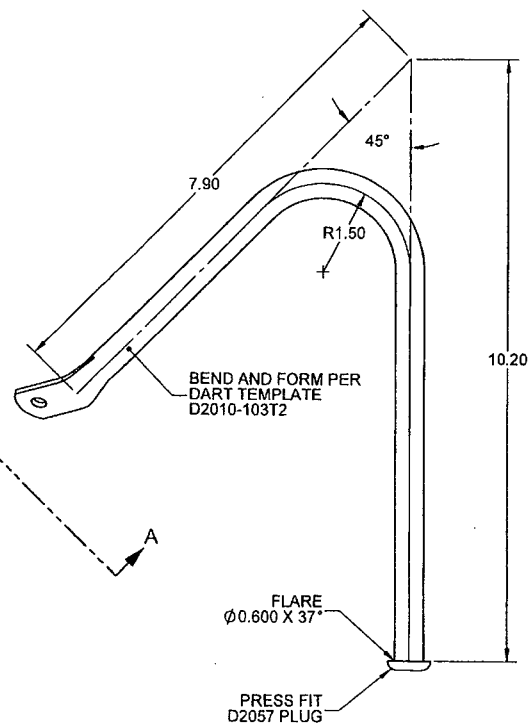
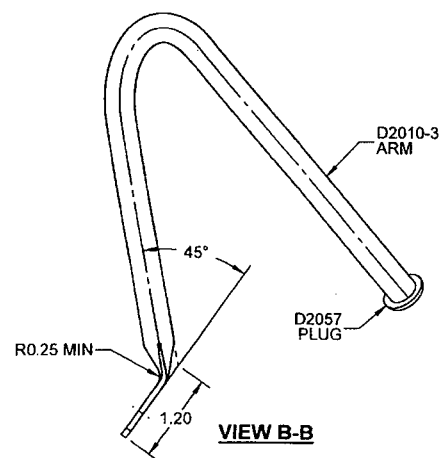
**NOTES:**

- 1) MATERIAL: D2010-1F: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-101" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: 0.23 lbs

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2010	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MIRROR BRACKET	NTS
DATE	08.06.10	COPYRIGHT © 1999 BY DART AEROSPACE LTD	
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QTY -103	P/N	DESCRIPTION
X	D2010-103	ARM
1	D2010-3	ARM
1	D2057	PLUG

RELEASED  
05-06-11

- NOTES:**
- 1) MATERIAL: D2010-3: AISI 304/316 SS SEAMLESS ROUND TUBING,  $\phi 0.500 \times 0.049$  WALL (REF DART SPEC M304TR0.500W.049)  $\triangle$
  - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-103" USING WHITE FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.34 lbs

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	JB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D2010	SHEET 3 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	MIRROR BRACKET	NTS
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